Quality Control

Work Orde Thursday, Septem											Page 1
Item ID: Revision ID:	D3286-3			Accept				S	Setup Star		
Item Name:	Spacer								Sto	p	
Start Date: Required Date:	9/29/2011 10/20/2011	Start Qty: 80.0 Req'd Qty: 80.0			Cust Item II Customer:	D:					
Reference:								•		4 1 10 0 11 16 1	Bija (2) (30) (80)
Approvals:	Process Pla	in: MLJ	Date: 9 20	Tooling:	Da	ıte:		ŀ	Run Sta		
	QC:		Date:	SPC (Y/N):	Da	ıte:			Sto	P	
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									,
D3286	Rev	' A								•	
Hardinge CNC Lathe	Small		IE SMALL aks as per Folio FA434 a s [per Dwg D3286	0.00 0.00 and Dwg D3286	29 11/10/03			80			
110 QC Quality Control		QC2- Inspect parts of Memo	f machine FAI/FAIB	0.00 SL	e 11/10/03			80			
120    <b>                 </b> QC		QC8- Inspect parts - s	econd check	0.00	1010104	<u>(</u>	•	89			

W/O:			WORK ORDER	WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
						_						
						<u> </u>						
Part No	):	PAR #:	Fault Category:	NCR: Ye	es No <b>DC</b>	A:	Date: _					
	F	esolution:	Disposition:	QA: N/C	Closed:		Date: _					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annroyal			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
							-				

### Work Order ID 74439

Page 2

Item ID:

Thursday, September 29, 2011 2:40:50 PM D3286-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Spacer

**Required Date:** 10/20/2011

9/29/2011

**Start Qty: 80.00** 

Req'd Qty: 80.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

Tool # Plan

Accept Qty

Reject Qty

Insp. Reject Number

Stamp

Memo

0.00

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

Code

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCI	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	):	PAR #:	Fault Category:	NCR: Ye	s No DC	A:	Date: _			
	R	esolution:	Disposition:	QA: N/C	Closed:		Date: _			

NCR:			WORK ORE	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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## **Picklist Print**

Thursday, September 29, 2011 2:40:56 PM

Work Order ID: 74439

Parent Item:

D3286-3

Parent Item Name: Spacer



Start Date: 9/29/2011

Required Date: 10/20/2011

**Start Qty: 80.00** 

Required Qty: 80.00

**Comments:** 

IPP A□04.07.14□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049	P18 418191 P2111 BB111 BB18 82118 1	Purchased	No			110	f	394.5211	0.3417	28.77474		. ,	
										SL	117	110/03	

304 RD Tube .500 x .049W

Location	Loc Qty	Loc Code	
MAT017	394.521058		
111814	2.23		
115010	145.421058		
117598	66.87		
<b>√</b> 119087	180		27.333

M304TR0.500W.049

M119087

M304TR0.500W.049

M119087

M304TR0.500W.049

M119087

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr OC Inspector

Part No:	•	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	1.4.140	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector	
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	-								
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DART AEROSPACE LTD	Work Order:	74439
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

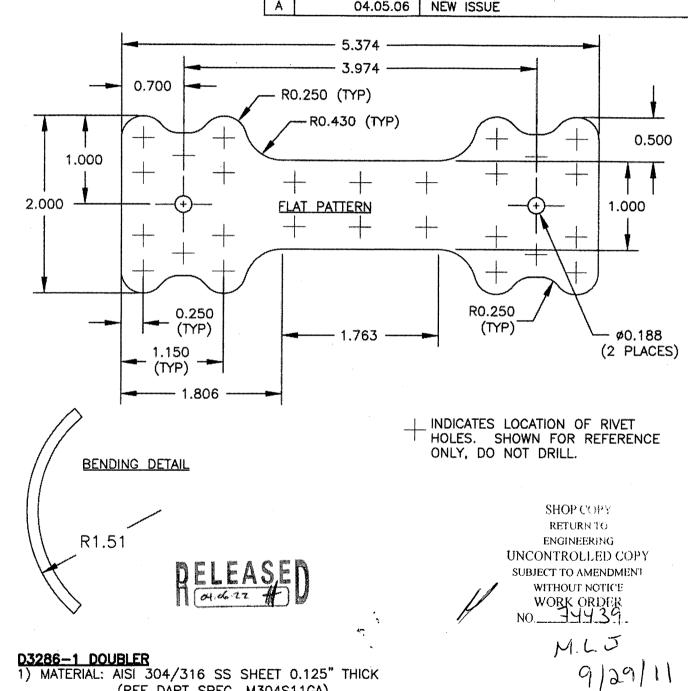
	FIRS	T ARTICLE II	NSPECTI	ON CH	ECKLIST		
		X First Arti	cle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
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0.500	+/-0.010	0-4995					
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Measured by:	SLPR	Audited by:			Prototype .	Approval:	N/A
Date:	11/10/03	Date:	uliel	04		Date:	N/A
Rev Date	Change					Revised þy	Approved
A 04.09.01	New Issue					KJ/JLM	- (11)

W/O:			W	ORK ORDER CHANG	ES		180.		
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		Dispositi	on:	_ QA: N/C	Closed:		Date: _		
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NC	R)		-	
DATE	STEP	Description of NC		ion B	Verifi	cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector
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CHECKED	APPROVED	DRAWING NO.		REV. A
#-	H	D3286		SHEET 1 OF 2
DATE		TITLE		SCALE
 04.05.06		GROUND	HANDLING PARTS	1:1
	04 05 00	11011 100		



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

BREAK ALL SHARP EDGES 0.010 TO 0.020

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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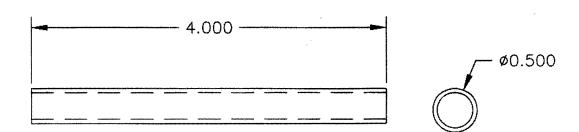
W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	l:	Date:

NCR:		,	WORK ORD	ER NON-CONFORMANC	E (NCR)							
		Description of NC	Corrective Action Section B			Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
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CHECKED	APPROVED,	DRAWING NO.			REV. A
#-		D3286		SHEE	T 2 OF 2
DATE	***	TITLE			SCALE
04.05.06		GROUND	HANDLING PAR	RTS	1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)

  2) BREAK ALL SHARP EDGES 0.010 TO 0.020

  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

  4) ALL DIMENSIONS ARE IN INCHES



W/O:		WORK ORDER O	HANGES												
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Part No: _		PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:	
•	Resolution:		Disposition:	QA: N/C Clos	ed:	Date:	

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)							
•		Description of NC		Corrective Action Section B			Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector		
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